



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043

Job Sheet 195761



Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/5/19		0.00	8.24	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		TF DD
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs	7/5/19		1.00	22.77	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		D. 19-06-21
130	QC 2	1 pcs	7/5/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S187955



Part: D5425-043

Job No: 195761

Serial No/Batch: S187955

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/05/19

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P.T.O.

				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	B.E 19-06-21
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
140 QC 8	1	7/5/19	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	19/06/23
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	19-06-21
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Handfinish - 1-1 Chemical-B4B	1	7/5/19	0.00 0.24	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JUN 24 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 -	

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				B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MLG
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
170 Skidtubes - Bend - 2 - B4B	1 pcs	7/5/19	0.50 2.63	Skidtubes - Bend - B4B	MLG
180 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	

190 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00	8.24	QC 5 - 30	
					QC 5 - 40	
					Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
200 QC 5	1 pcs	7/5/19	0.00	0.00	Skidtubes - 7 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
210 Handfinish - 6-1- Touch Up- B4B	1 pcs	7/5/19	0.00	0.24	Handfinish - 6 - 1 - B4B	
					Handfinish - 6 - 2 - B4B	
					Handfinish - 6 - 3 - B4B	
					Handfinish - 6 - 4 - B4B	
					Handfinish - 6 - 5 - B4B	
					Handfinish - 6 - 6 - B4B	
					Handfinish - 6 - 7 - B4B	
					Handfinish - 6 - 8 - B4B	
					Handfinish - 6 - 9 - B4B	
					Handfinish - 6 - 10 - B4B	
					Handfinish - 6 - 11 - B4B	
					Handfinish - 6 - 12 - B4B	
					Handfinish - 6 - 13 - B4B	
					Handfinish - 6 - 14 - B4B	
					Handfinish - 6 - 15 - B4B	
					Handfinish - 6 - 16 - B4B	
					Handfinish - 6 - 17 - B4B	
					Handfinish - 6 - 18 - B4B	
					Handfinish - 6 - 19 - B4B	
					Handfinish - 6 - 20 - B4B	
					Handfinish - 6 - 21 - B4B	
					Handfinish - 6 - 22 - B4B	

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220 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	m/h
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
230 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 8.24	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
240 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Handfinish - 6-2- Touch Up- B4B	1 pcs	7/5/19	0.00 0.00	Handfinish - 6 - 1 - B4B	
				Handfinish - 6 - 2 - B4B	
				Handfinish - 6 - 3 - B4B	
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	

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				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
260 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	AR 19-7-15
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
270 Spray Paint - 2 - B4B	1 pcs	7/5/19	0.00 0.00	Spray Paint - 1 - B4B	AR 19-7-15
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
280 QC 14	1 pcs	7/5/19	0.00 0.00	QC 14 - 15	M 19-7-16

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				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
282 Outsource - 11 - Paint	1 pcs	7/5/19		ATE003-VC	2
284 Packaging 2-1 - Receive - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
286 QC 6	1 pcs	7/5/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
290 Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00 0.24	Handfinish - 4 - 1 - B4B	19-7-11
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 -	

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				B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
300 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
310 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

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JUL 17 2019

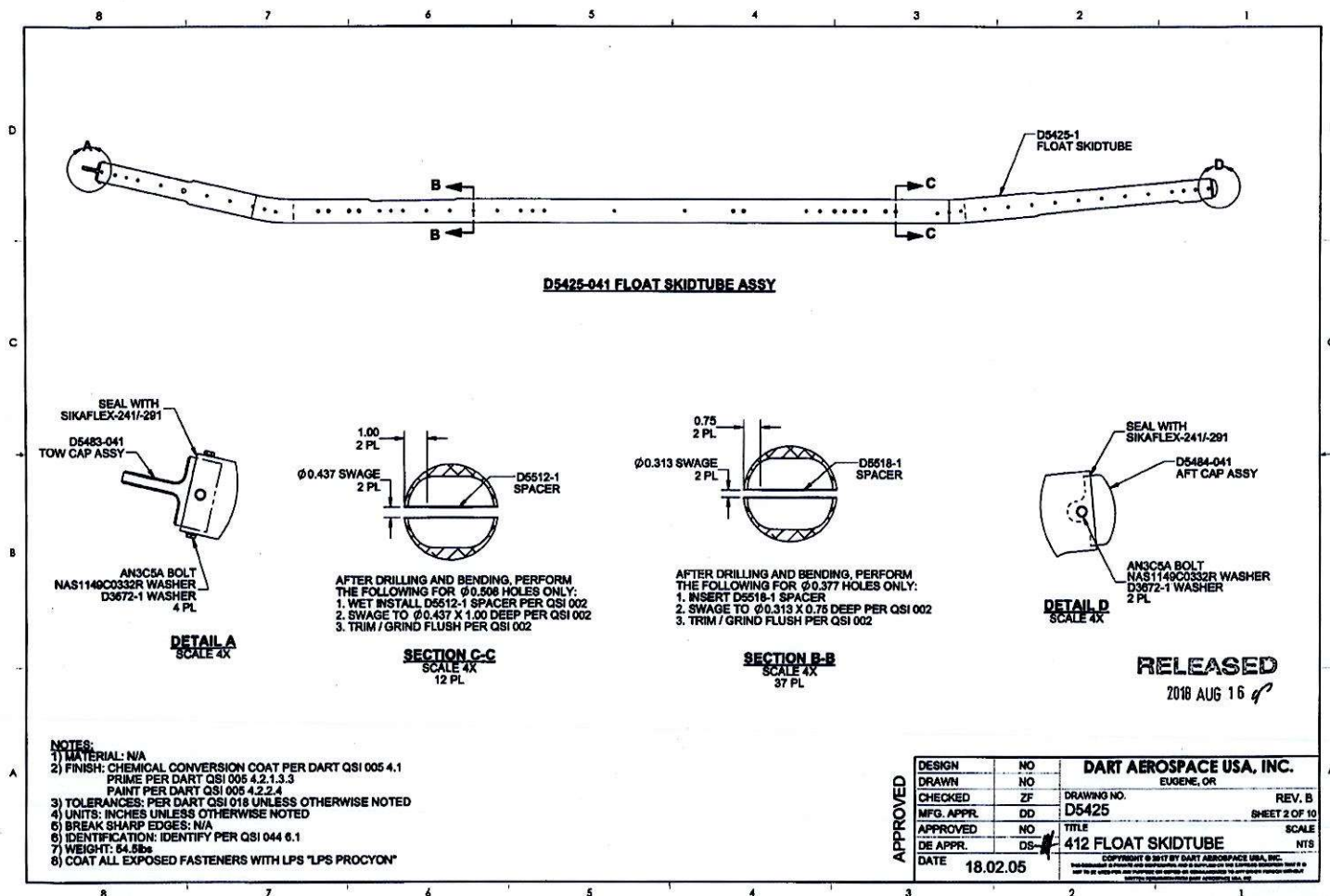
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	21
				Packaging 3 - 36 - B4B	21
320 QC 21 - SA	1 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	JUL 23 2019
				QC 21 - SA - 70	JUL 23 2019
				QC 21 - SA - 53	JUL 23 2019

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Deburr ends as per Dwg.
 Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: B FOLIO REV: AA 2-Deburr as per Dwg.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 150 - 1-Scrub inside of tube with medium scotchbright.
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - 1-Bend Aft end of tube as per Dwg. and Folio 4.530. Insert Bending mandrel DT 10328 at 20.0" from aft end. Use buggy A,B,C. to stabilize tube. HEIGHT 4.530 2-Bend Forward end of tube as per Dwg. and Folio 7.500. Insert Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C To stabilize tube. HEIGHT 7.500 3-Record dimensions on work order.
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - 1-Drill remaining holes of DETAIL M, N, P. USING DT10340 A,B,C,D 2-Open holes to finished size as per Dwg. 3-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.
 200 - (QC5- Inspect part completeness to step on W/O)
 220 - (QC7-Inspect Chemical Conversion Coat)
 230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B S108160 Start Time: 11:00 AM Finish Time: 5:00 PM ***CURE TIME 6HRS. BEFORE PROCEEDING TO NEXT STEP*** 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Touch up alodine) ***DO NOT SUBMERGE TUBE IN DEOXODIZER***
 260 - (QC7-Inspect Chemical Conversion Coat)
 270 - (Spray Paint / NDT Room) ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: S189559 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: S192331
 280 - (QC14- Inspect Spray Paint)
 282 - ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: S192331 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: S192331
 284 - C OF C IS REQUIRED
 290 - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B 4432690 Exp; 4432690
 Start time: 4:00 PM Finish time: 4:00 PM 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon B 4432690
 300 - (QC5- Inspect part completeness to step on W/O)
 310 - (Identify as per dwg & Stock Location: 4432690)
 320 - (QC21- Final Inspection - Work Order Release)

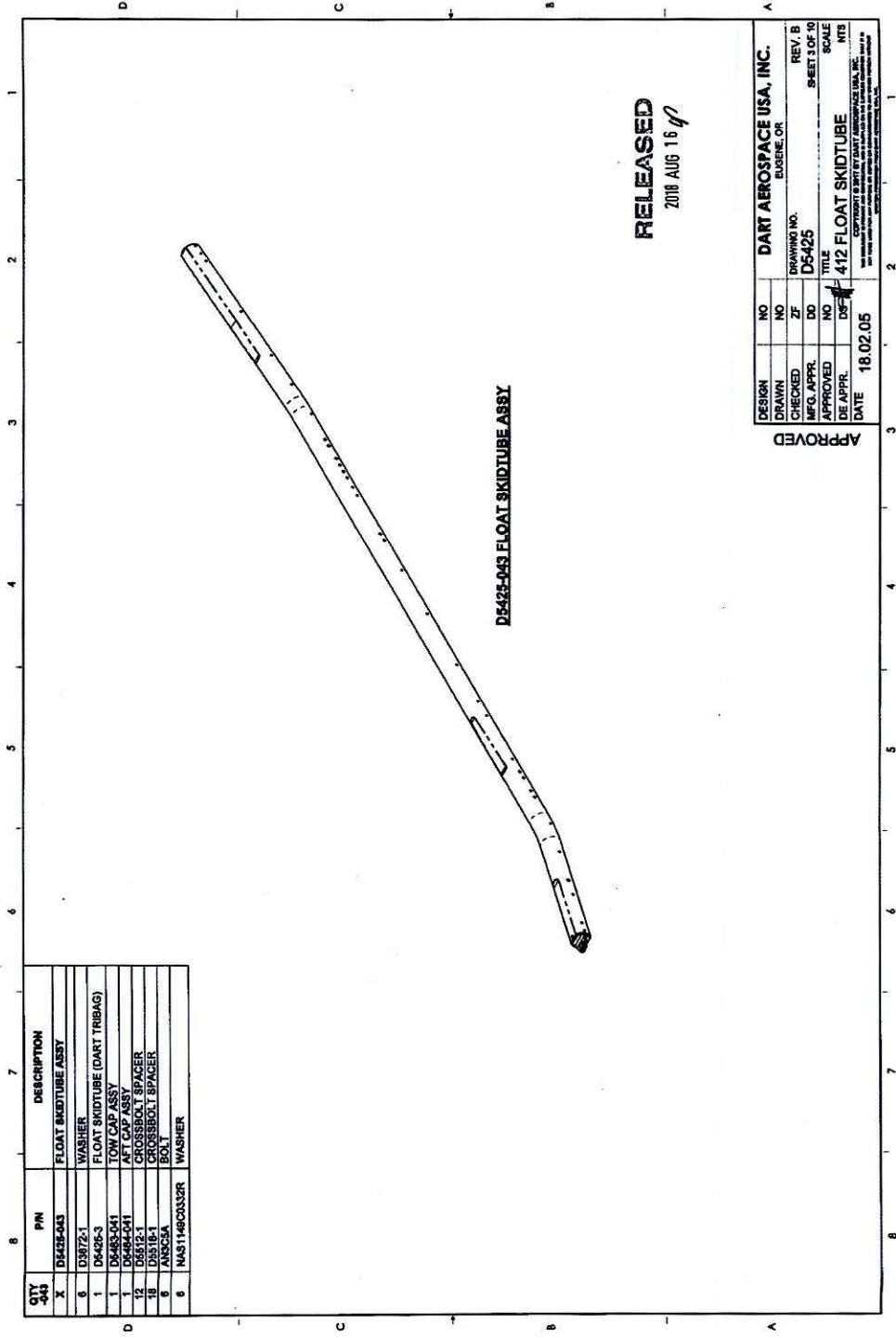
Job BOM					010947
Part / Item	Component Name	Quantity	Operation	Container	
D6028-195	Crosstube Material, 7075-T73/T73511	1 pcs (1 ea)	110-Skidtubes - 1	<u>S183903</u>	
D5518-1	Crossbolt Spacer	18 pcs (18 ea)	230-Skidtubes - 3 - B4B	<u>S187624</u>	
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B	<u>S192144</u>	
AN3C5A	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>F164009</u>	
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>S15017</u>	
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>S151947</u>	
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>S158674</u>	
NAS1149C0332R	Washer	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B		

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D6028-195	1	21	0
230-Skidtubes - 3 - B4B	D5512-1	12	42	0
	D5518-1	18	272	0
290-Handfinish - 4-1-Assembly-B4B	AN3C5A	6	1,118	0
	D3672-1	6	1,677	0
	D5483-041	1	10	0
	D5484-041	1	9	0
	NAS1149C0332R	6	2,970	0
Part Specifications				
Specifications could not be found.				

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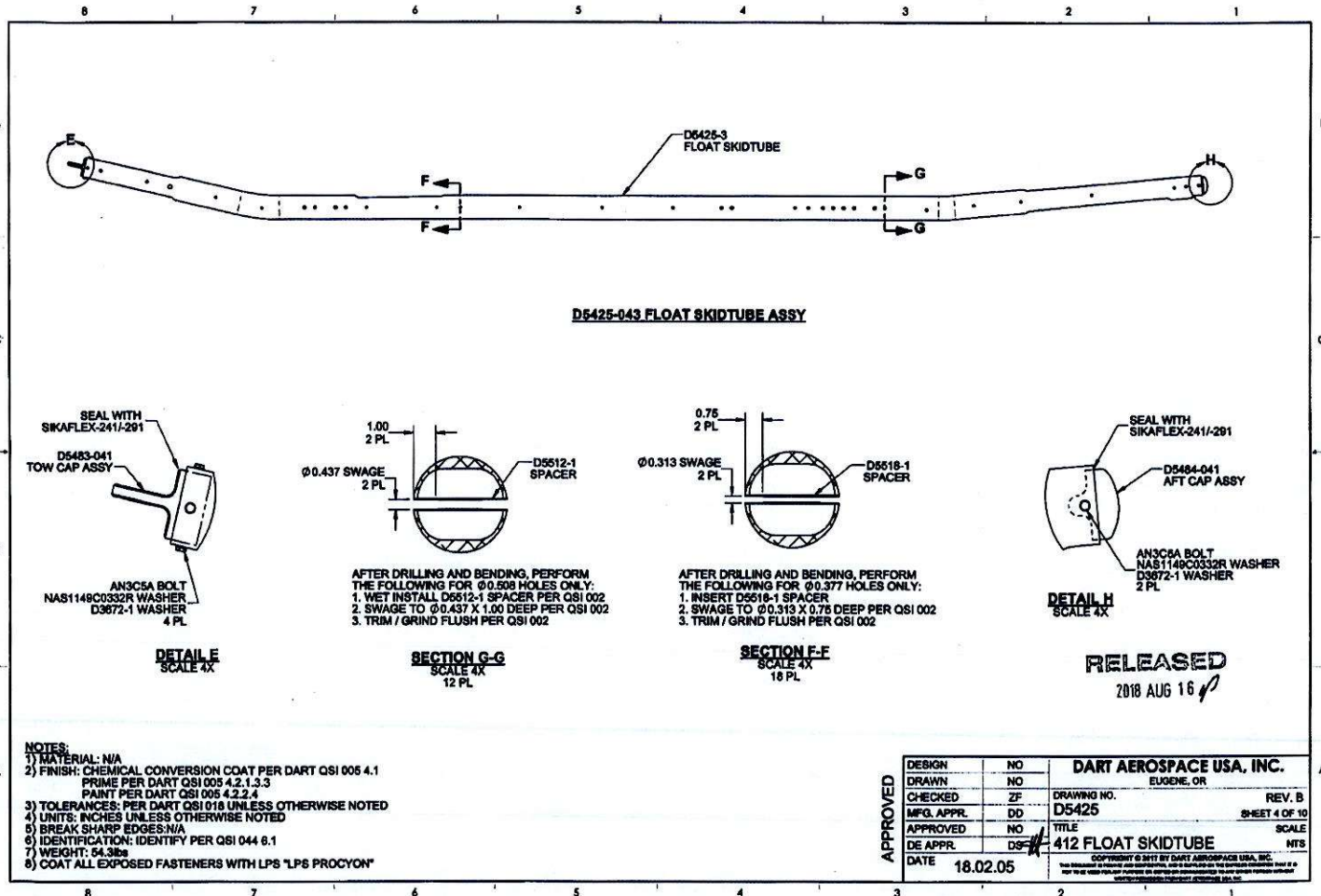


QTY -Q41	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D5872-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5485-041	TOW QSP ASSY
1	D5412-041	W/SPACER
12	D5412-1	CROSSBOLT SPACER
18	D5418-1	CROSSBOLT SPACER
6	AN505A	BOLT
6	NAS1480332R	WASHER



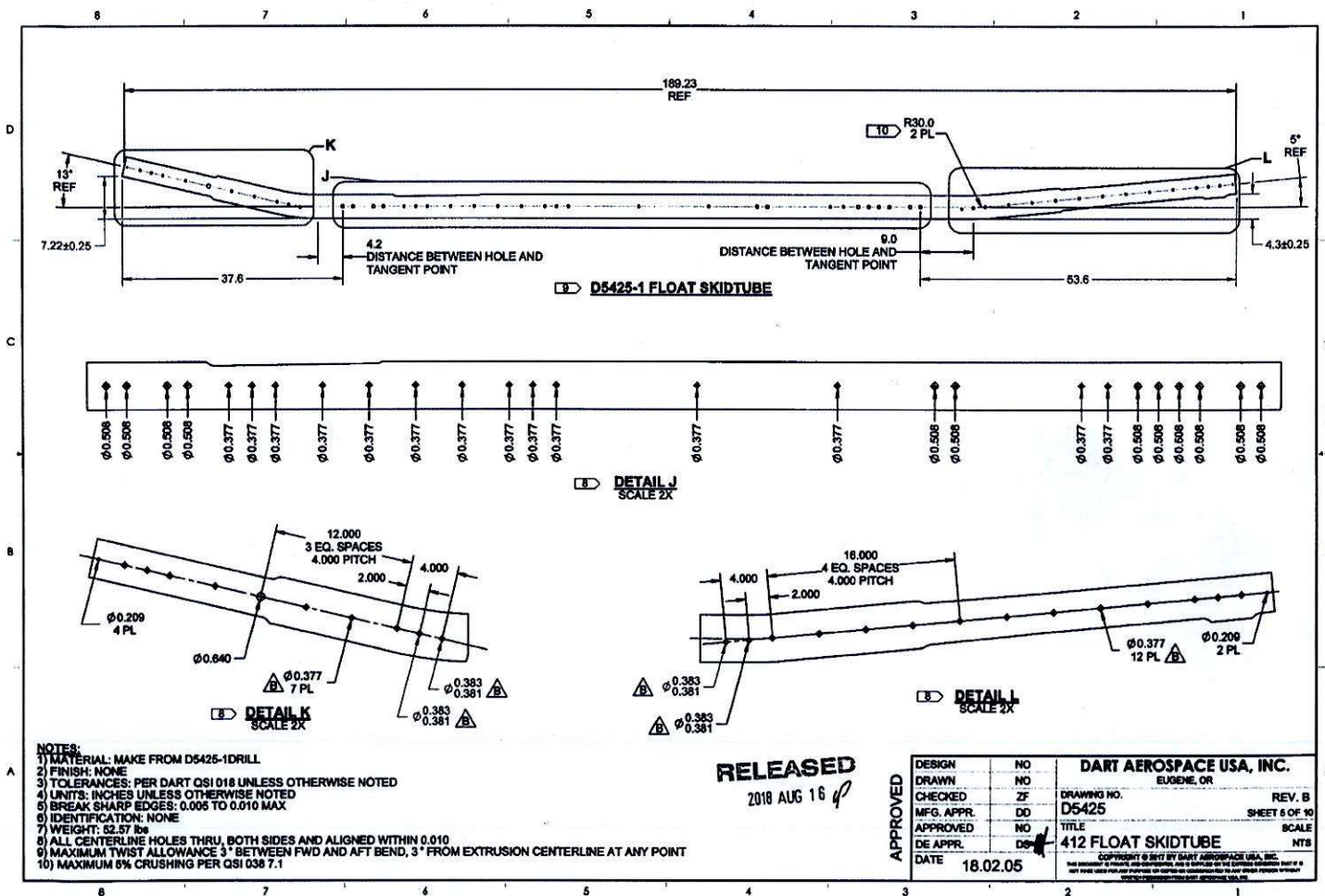
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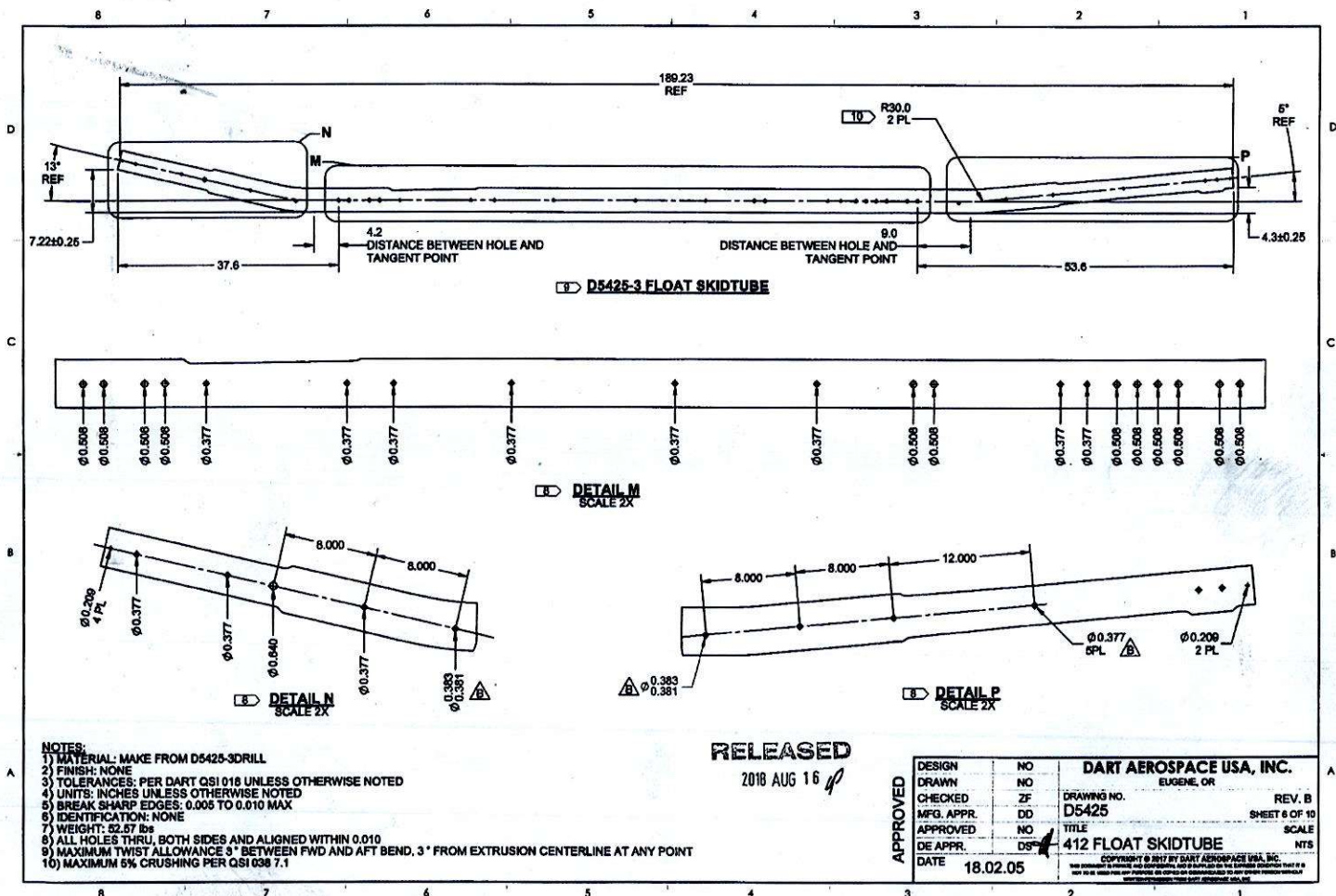
DESIGN				DART AEROSPACE USA, INC.			
DRAWN	NO	NO	NO	NO	NO	NO	NO
CHECKED	2F	2F	2F	2F	2F	2F	2F
INFO. APPL.	DO	DO	DO	DO	DO	DO	DO
APPROVED	NO	NO	NO	NO	NO	NO	NO
DE APPL.	DS	DS	DS	DS	DS	DS	DS
DATE	18.02.05	18.02.05	18.02.05	18.02.05	18.02.05	18.02.05	18.02.05
REV. B				REV. B			
DRAWING NO.				DRAWING NO.			
D5425				D5425			
TITLE				TITLE			
412 FLOAT SKIDTUBE				412 FLOAT SKIDTUBE			
SCALE				SCALE			
NKS				NKS			
DATE				DATE			
18.02.05				18.02.05			
APPROVED				APPROVED			
DATE				DATE			
18.02.05				18.02.05			

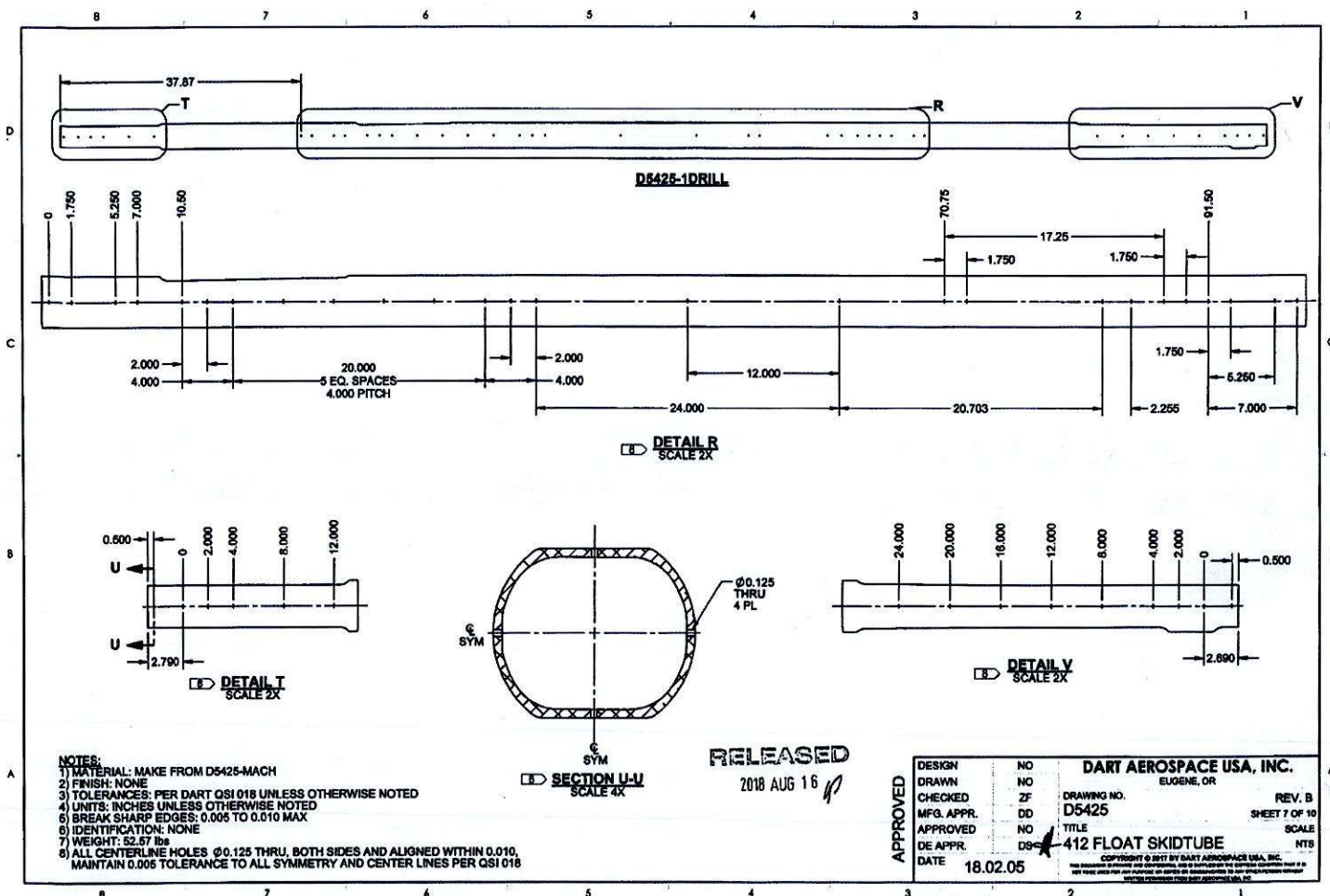


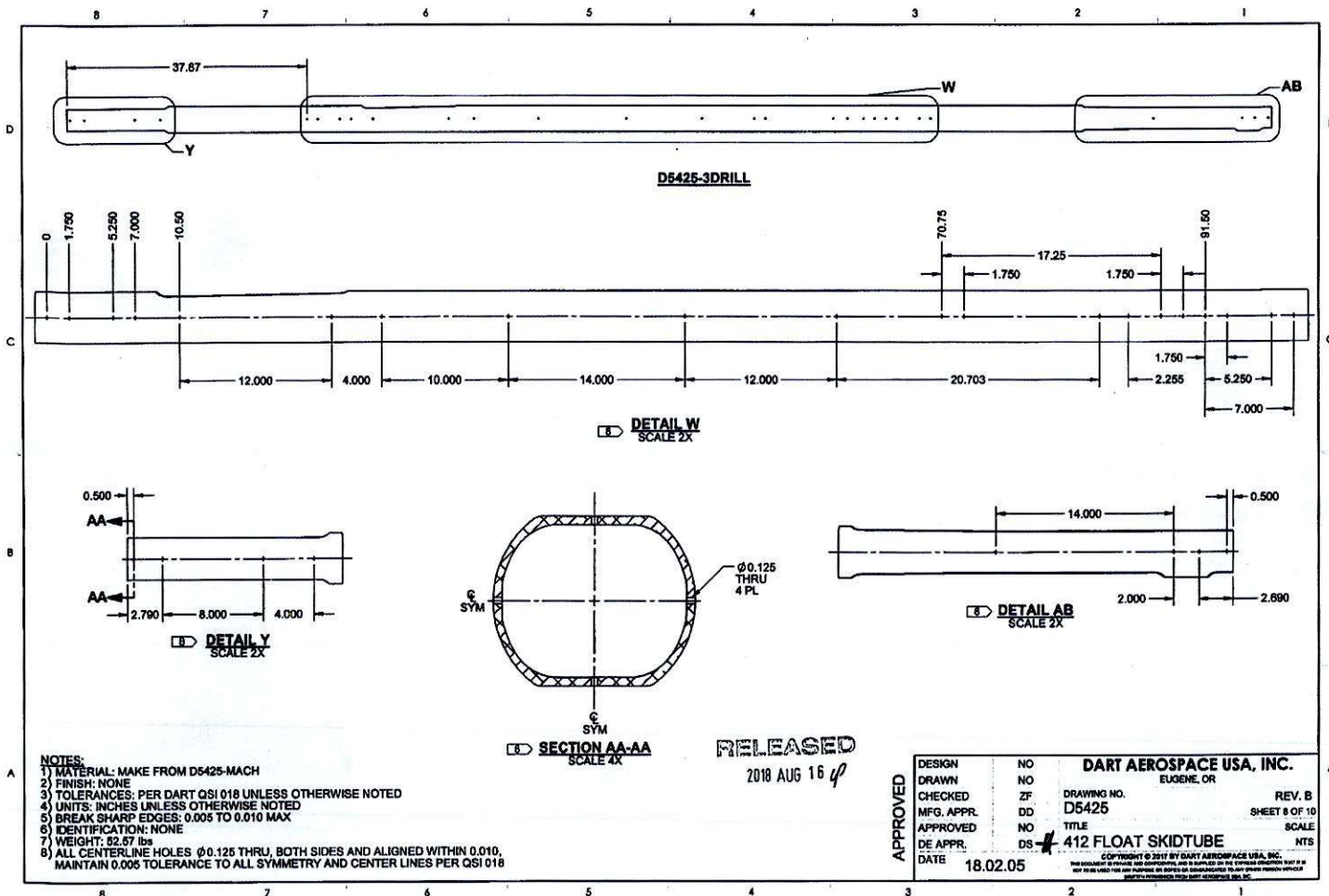
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 54.3lb
 - 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

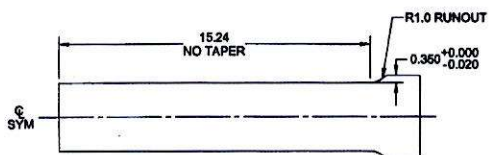
DESIGN		NO		DART AEROSPACE USA, INC.	
DRAWN		NO		EUGENE, OR	
CHECKED		ZF		REV. B	
MFG. APPR.		DD		D5425 SHEET 4 OF 10	
APPROVED		NO		SCALE	
DE APPR.		DS		412 FLOAT SKIDTUBE NTS	
DATE		18.02.05		COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	



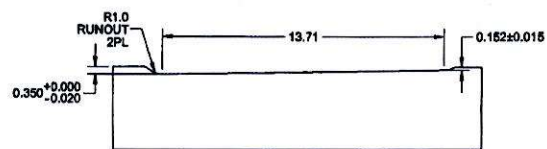




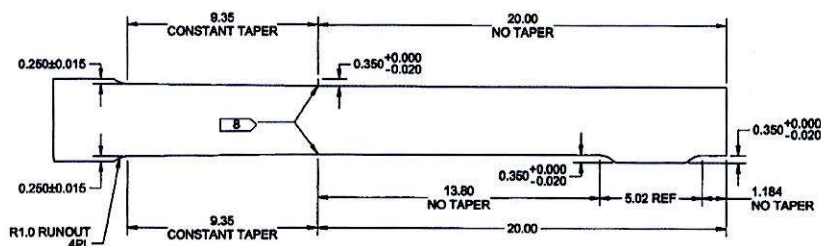




DETAIL AE
SCALE 3X



DETAIL AF
SCALE 3X



DETAIL AG
SCALE 3X

RELEASED
2018 AUG 16

APPROVED	DESIGN	NO	DART AEROSPACE USA, INC.	
	DRAWN	NO	EUGENE, OR	
	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 10 OF 10
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
	DATE	18.02.05	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND NOT FOR DISSEMINATION TO ANY OTHER PERSON OR ENTITY WITHOUT EXPRESS WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DART AEROSPACE LTD		Work Order: 195761
Description: 412 FLOAT SKIDTUBE		Part Number: D5425-3
Inspection Dwg: D5425 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- .010	0.500	✓		Dial ind.	HAAS4
2.790	+/- .010	2.790	✓		"	"
10.790	+/- .010	10.790	✓		"	"
14.790	+/- .010	14.790	✓		"	"
43.120	+/- .010	43.116	✓		"	"
44.870	+/- .010	44.866	✓		"	"
48.37	+/- .010	48.366	✓		"	"
60.37	+/- .010	60.366	✓		"	"
64.37	+/- .010	64.366	✓		"	"
74.37	+/- .010	74.366	✓		"	"
123.328	+/- .010	123.328	✓		Tape	ref.
125.87	+/- .010	125.87	✓		"	"
129.37	+/- .010	129.37	✓		"	"
131.12	+/- .010	131.12	✓		"	"
134.62	+/- .010	134.62	✓		"	"
136.37	+/- .010	136.37	✓		"	"
0.500	+/- .010	0.500	✓		Dial ind.	HAAS4
2.690	+/- .010	2.690	✓		"	
4.69	+/- .010	4.69	✓		"	
18.69	+/- .010	18.69	✓		"	
15.24	+/- .030	15.24	✓		Tape	ref.
R1.0	+/- .100	R1.000	✓		R-6	ref.
0.350	+ .000 / - .020	0.344	✓		Dial ind.	HAAS4
0.350	+ .000 / - .020	0.338	✓		"	"
R1.0	+/- .100	R1.000	✓		R-6	ref.
13.71	+/- .030	13.71	✓		TAPE	ref.
0.152	+/- .015	0.140	✓		Dial ind.	HAAS4
0.250	+/- .015	0.237	✓		"	"
9.35	+/- .030	9.35	✓		Tape	ref.
0.350	+ .000 / - .020	0.345	✓		Dial ind.	HAAS4
20.00	+/- .030	20.00	✓		Tape	ref.
0.250	+/- .015	0.240	✓		Dial ind.	HAAS4

Measured by: JF	Checked by: JF	QC Inspector:
Date: 19-06-21	Date: 19/06/23	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

